

Work Order ID 161616

Thursday, May 18, 2017 2:44:29 PM

161616

Page 1

Item ID: D2662-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd, Aft, Out
 Start Date: 6/12/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/23/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: DA **DAS 21 9-89** Date: 5-17-2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100		1.08							DAS 44 9-89
100	HAAS CNC VERTICAL MACHINING #1					<u>4</u>	<u>0</u>		<u>17-06-04</u>
HAAS 1	Memo	1.66							
HAAS CNC vertical machine #1	Program part number and batch number. Inspect part number and batch number are programmed								
	MACHINE AS PER FOLIO FB069 & DWG DWG REV: <u>E</u> FOLIO REV: <u>E</u>								
110		0.00							DAS 44 9-89
110	CONVENTIONAL MILLING MACHINE					<u>4</u>	<u>0</u>		<u>17-06-04</u>
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.04				4	0		DAS 44 9-89 17-06-08
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4	0		DAS 20 9-89 17-06-08
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.27				(x4)	0		201706/08 BEB

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WORK ORDER NON-CONFORMANCE / UPDATE



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
SAC M 19/04/20								Lead hand / Supervisor Approval Verification																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M137176</i> Memo START TIME: <i>10:10</i> OVEN TEMPERATURE: <i>370</i> FINISH TIME: <i>10:40</i>	0.00 0.25				<i>H</i>	<i>Φ</i>	<i>17.06-9</i>	<i>333</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<i>4</i>			<i>DAS</i> <i>38</i> <i>9-89</i> <i>JUN 12 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>8401</i> Memo	0.00 0.04				<i>4</i>			<i>DAS</i> <i>6</i> <i>9-89</i> <i>JUN 14 2017</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

JUN 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, May 24, 2017 11:52:49 AM

Page 1

Work Order ID: 161616

161616

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, LH Fwd, Aft, Out

Start Date: 6/12/2017

Required Date: 6/23/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	1.0000	1	4			
D6101-001									**				
Saddle Billet													

DAS
44
9-89 17-06-04

Location Loc Qty Loc Code

MAT042

1

159317

1

161493

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 161 616
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 1

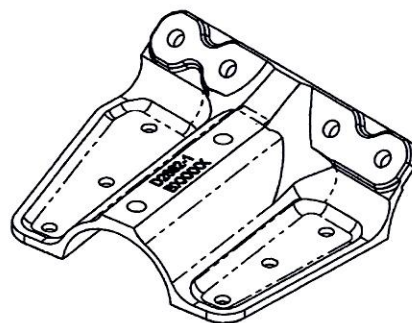
FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.614	3.614	3.614	3.614	
B	0.256	0.263		.258	.258	.258	.258	
C	0.315	0.322		.316	.316	.316	.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	0.100	0.140		.121	.122	.122	.122	
G	0.210	0.230		.221	.221	.221	.220	
H	0.615	0.685		.685	.685	.685	.685	
I	2.470	2.510		2.494	2.494	2.493	2.494	
J	1.313	1.343		1.323	1.324	1.326	1.324	
K	0.178	0.198		.188	.188	.188	.188	
L	0.470	0.530		.500	.500	.500	.500	
M	1.125	1.145		1.135	1.135	1.135	1.135	
N	0.100	0.180		.140	.140	.140	.140	
O	0.100	0.140		.134	.132	.133	.133	
P	0.240	0.260		.251	.249	.250	.251	
Q	0.677	0.697		.687	.687	.687	.688	
R	0.540	0.560		.550	.550	.550	.550	
S	0.912	0.932		.922	.922	.922	.922	
T	0.787	0.807		.797	.799	.798	.797	
U	5.990	6.010		6.000	6.000	6.000	6.000	
V	4.995	5.005		5.000	5.000	5.000	5.000	
W	0.490	0.510		.500	.500	.500	.500	
X	0.312	0.319		.313	.313	.313	.313	
Y	0.990	1.010		1.000	1.000	1.000	1.000	
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	
AB	0.490	0.510		.500	.500	.500	.500	
AC	3.745	3.755		3.750	3.750	3.750	3.750	
AD	0.100	0.140		.123	.130	.131	.128	
AE	0.235	0.240		.238	.238	.238	.238	
AF	0.510	0.515		.510	.510	.510	.510	
AG	0.100	0.120		.113	.113	.113	.113	
AH	1.565	1.585		1.575	1.575	1.575	1.575	

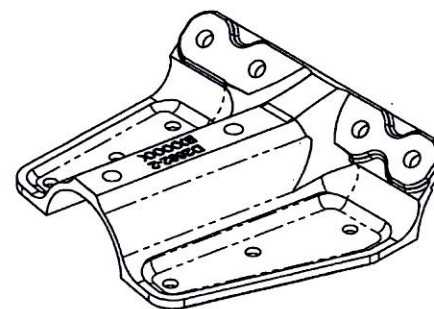
DAS Accept/Reject

Measured by: 44	Date: 17-06-05
Audited by: 20	Date: 17-06-05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	



D2662-1 SADDLE, INSIDE, LH



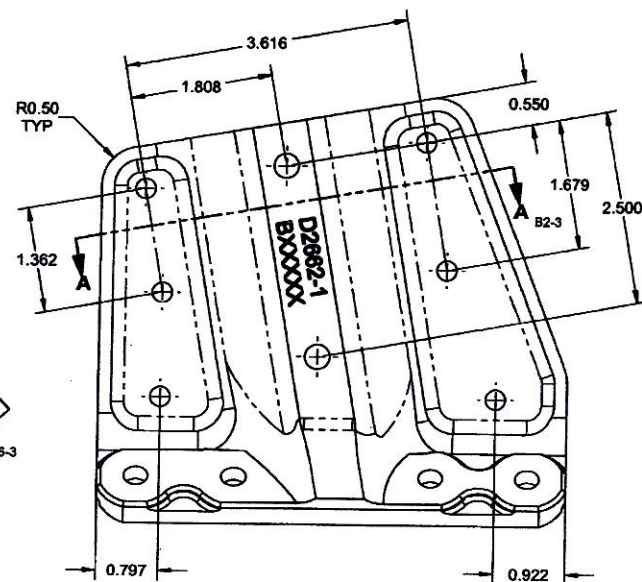
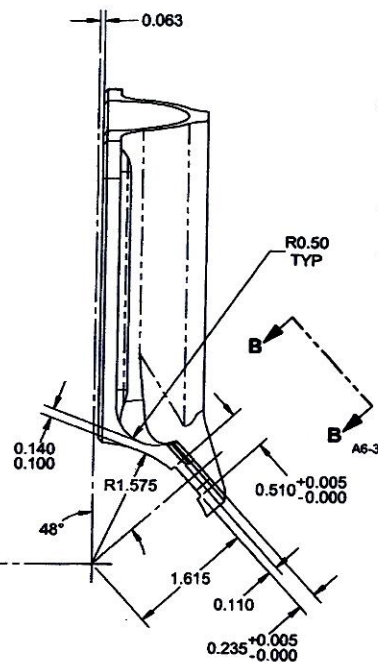
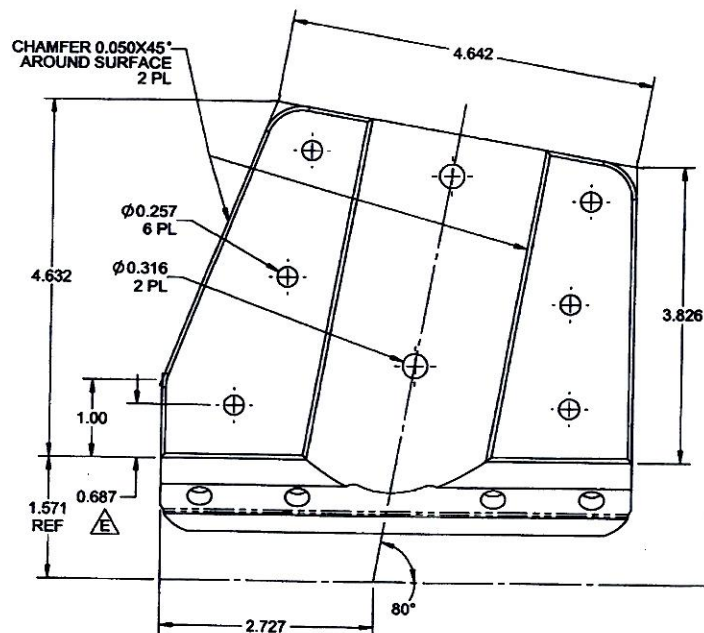
D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1161616

RA 2017/05/14

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4); REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
DESIGN	DART AEROSPACE USA, INC. KENT, WA		
DRAWN	DRAWING NO. D2662 REV. E		
CHECKED	SHEET 1 OF 5		
MFG. APPR.	TITLE SADDLE, INSIDE SCALE NTS		
APPROVED	DATE 11.10.31		
DE APPR.	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

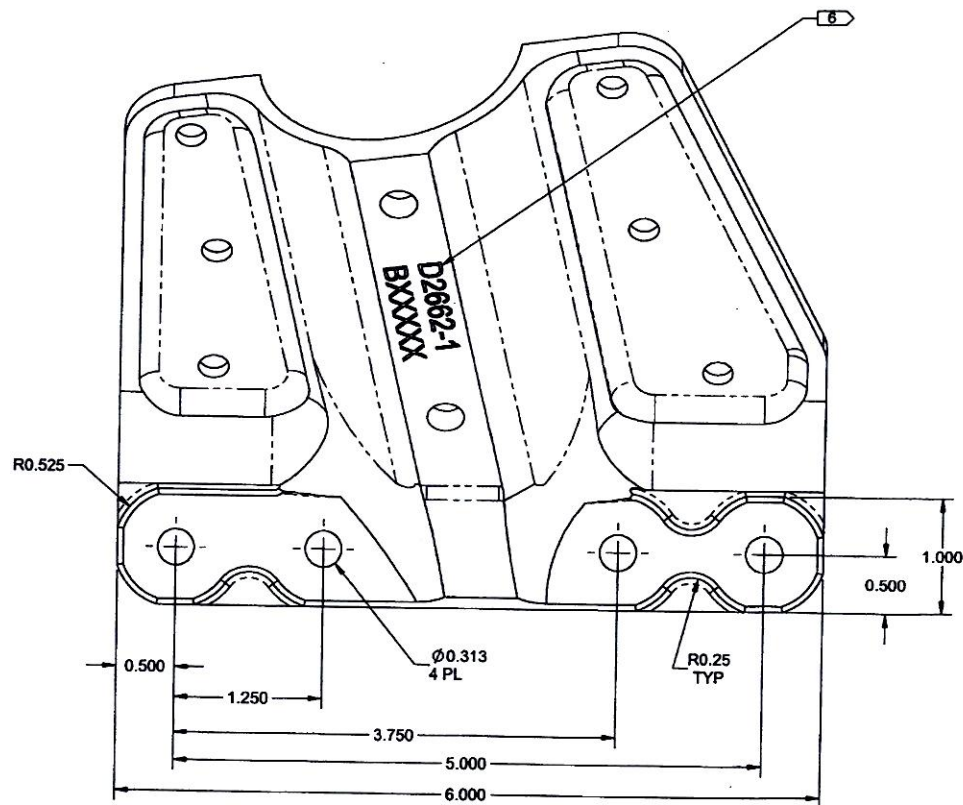


D2662-1 SADDLE, INSIDE, LH

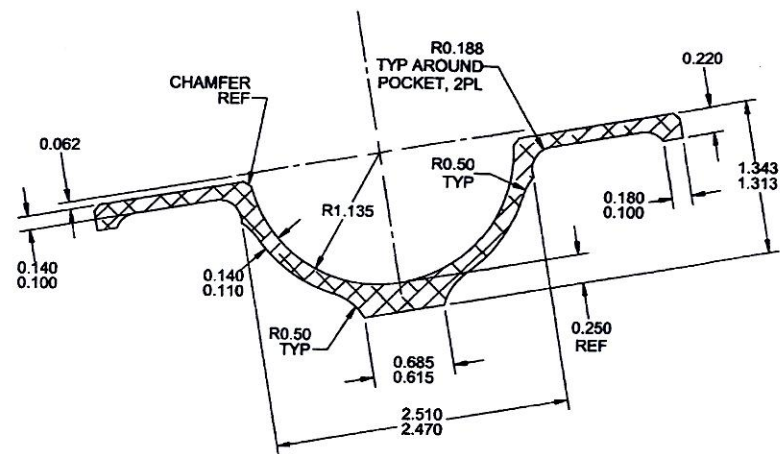
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

RELEASE
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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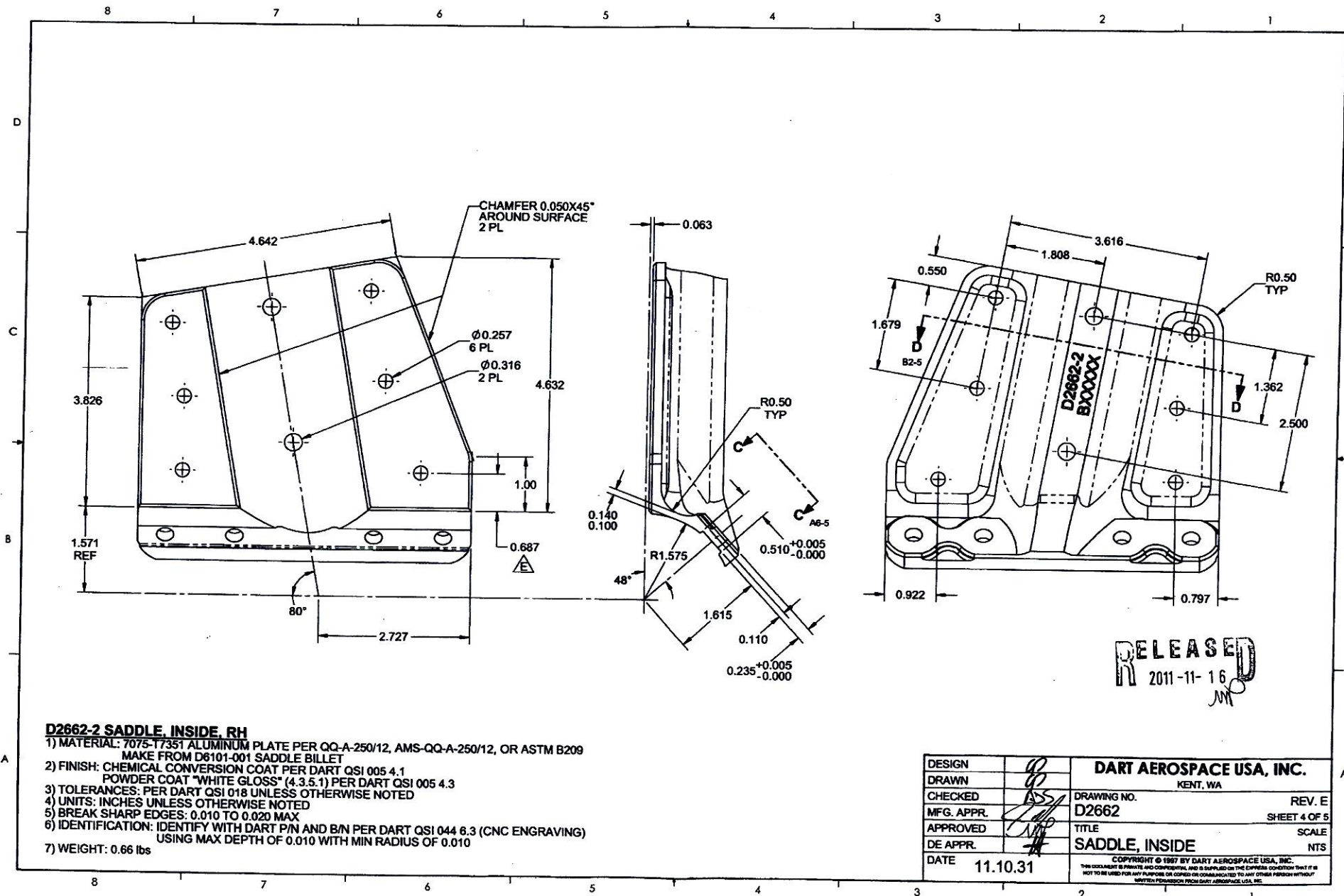
VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED

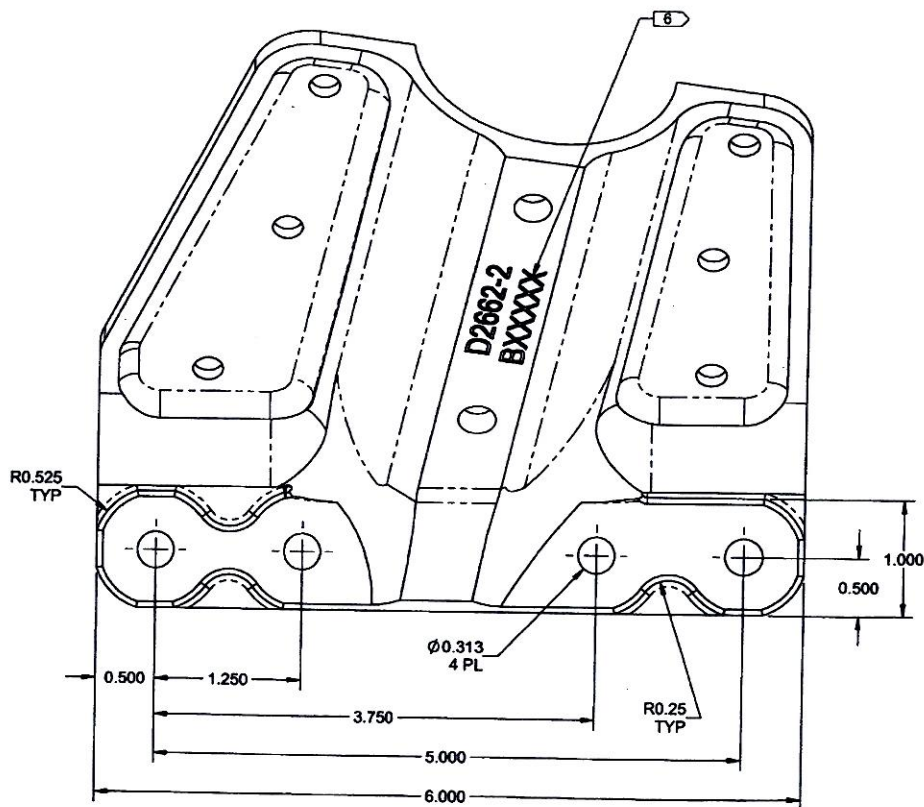


VIEW A-A
SCALE 1.5X C1-2

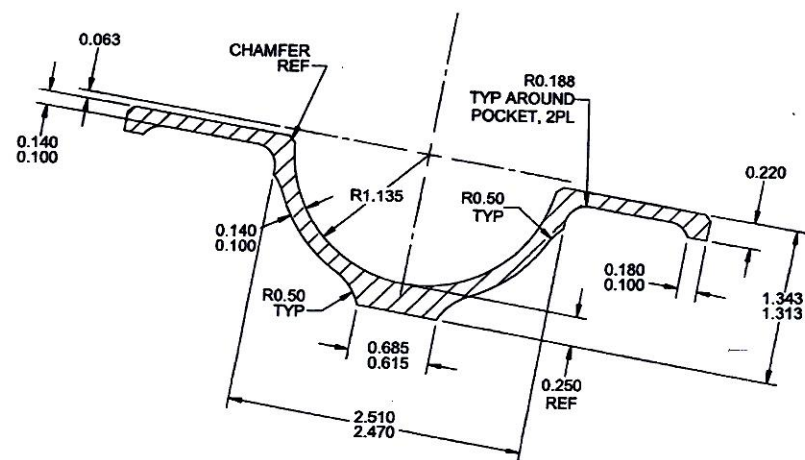
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VIEW D-D
SCALE 1.5X
VIEW ROTATED



VIEW C-C
SCALE 1.5X
C3-4

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